

Work Order ID 163005

Tuesday, June 20, 2017 1:34:42 PM

163005

Page 1

Item ID: D212-725-1-949 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Duct Assembly
Start Date: 6/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 13 9-89** Date: **JUN 20 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4065	C								

110

110

Purchasing

Purchasing

THERMOFORMING MACHINE

Memo

ISSUE P/O: **36772**
SUPPLIER: PLASTECH

MANUFACTURE D212-725-251 / 253 AS PER DWG. D4065

C OF C IS REQUIRED

0.00

0.00

1 JUN 20 2017**DAS****13****9-89**

140

140

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

1 X 6/27/17

Work Order ID 163005***163005***

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Tuesday, June 20, 2017 1:34:42 PM

Item ID: D212-725-1-949

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Duct Assembly

Start Date: 6/20/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/27/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 SEP 27 2017

155

0.00

155

Small Fab

Memo

0.00

Small Fab

1-Scuff mating edges with scotchbrite pad, wipe with wash & wipe and allow to dry.

2-Clamp D4065-1 and D4065-3 to assembly fixture DT9508

3-Seal mating edges with EZ Adhesive along perimeter with a minimum thickness of 0.020"

4-Clean any excess glue from newly sealed edges

M12
DAS
38
9-89

Work Order ID 163005***163005***

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Tuesday, June 20, 2017 1:34:42 PM

Item ID: D212-725-1-949 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Duct Assembly
Start Date: 6/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			POSITIVE RECALL JUL 11 2017 EFFECTIVE AUTH RELEASED DAS 9-89 DATE R.O.N.						
170 *170* Packaging Packaging	Identify as per dwg & Stock Location ST 169A Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

C217109/27

Picklist Print

Tuesday, June 20, 2017 1:34:40 PM

Page 1

Work Order ID: 163005

163005

Parent Item: D212-725-1-949

D212-725-1-949

Parent Item Name: Duct Assembly

Start Date: 6/20/2017

Required Date: 6/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.09.14 NEW ISSUE DD VERF:EC IPP Rev B
14/01/20 Change "Folio" to Work Instruction DL IPP Rev.C 17.06.20
Now outside process DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-1-949P		Purchased		No			Each	0.0000		1			
D212-725-1-949P									**				
Duct Assembly													

D212-725-1-251 x1

JUN 20 2017

DAS
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9-89

D212-725-1-253 x1

JUN 20 2017

DAS
13
9-89

E2 250150 x 5 N/A

JUN 21 2017

DAS
13
9-89

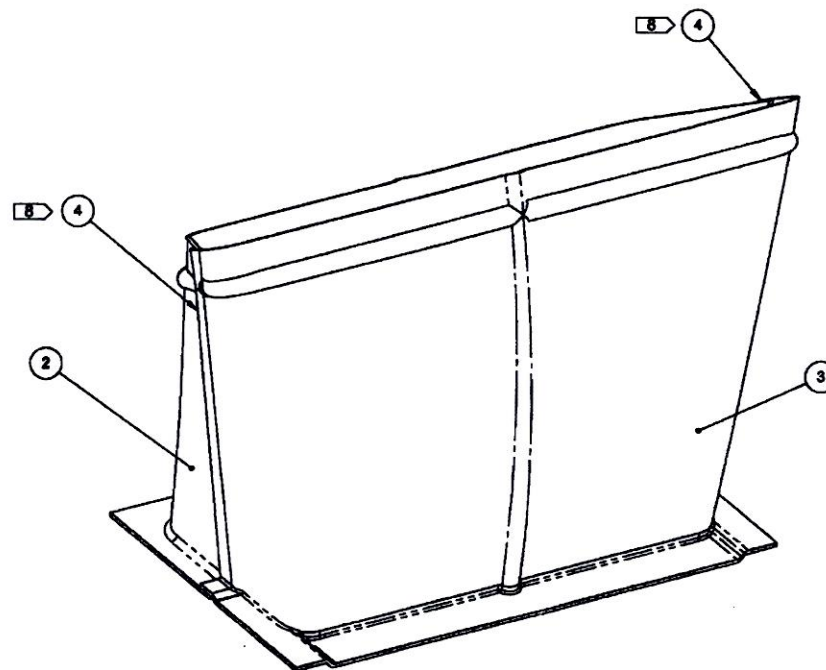
MLEXS.093-F6006-02

JUN 21 2017

DAS
13
9-89

3.958F m 127208.

ITEM	QTY	P/N	DESCRIPTION
1	X	D212-725-1-949	DUCT ASSEMBLY
2	1	D212-725-1-251	FWD DUCT
3	1	D212-725-1-253	AFT DUCT
4	A/R	EZ250150	ADHESIVE, 3M SCOTCH WELD OR DEVCON PLASTIC WELDER II



D212-725-1-949 DUCT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.68 lbs
- 8) SEAL MATING EDGES WITH EZ250150 ADHESIVE OR DEVCON PLASTIC WELDER II ALONG MATING PERIMETER WITH MINIMUM THICKNESS OF 0.020"

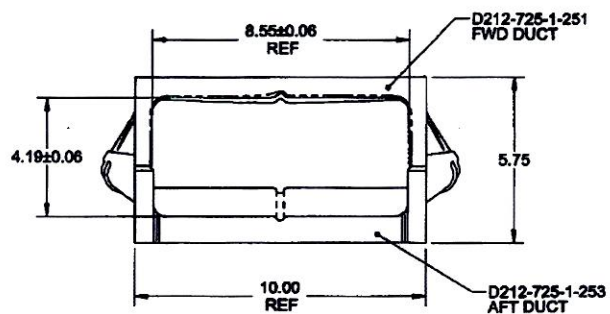
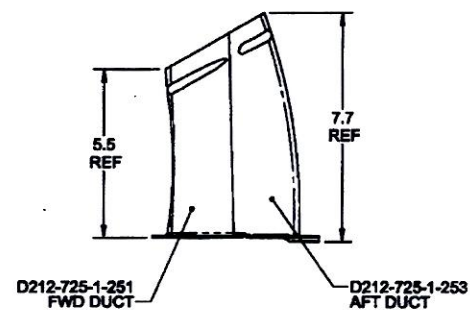
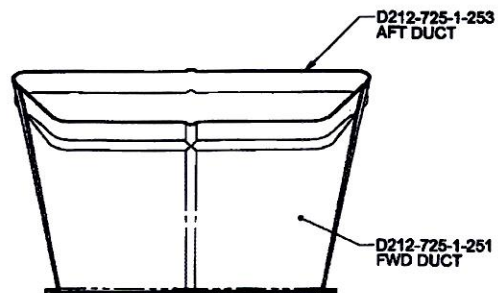
**DAS
13
9-89**

JUN 20 2017

W10-163005

RELEASED
2013-10-07

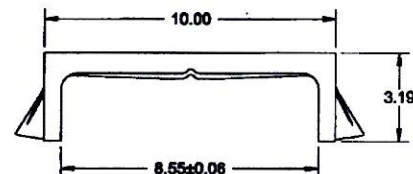
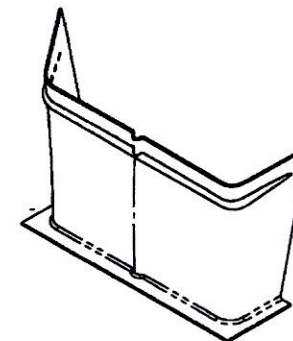
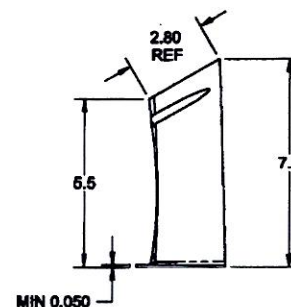
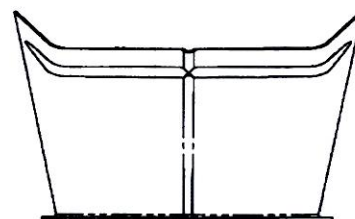
C	REVISE NOTES TO ADD DEVCON PLASTIC WELDER II OPTION. REASON: SHOP REQUEST.	SFM	13.07.15
B	D212-725-1-949 WAS D4065-041 (ZN A4-1, D3-1, A4-2); D212-725-1-251 WAS D4065-1 (ZN A4-3, D3-1, CA-2); D212-725-1-253 WAS D4065-3 (ZN A4-4, D3-1, D4-2, B4-2, C1-2)	RF	11.02.24
A	NEW ISSUE	RF	10.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4065	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DUCT ASSEMBLY	NTS
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D212-725-1-949 DUCT ASSEMBLY

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2013-10-07
WJD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		SCALE	NTS
DE APPR.		DUCT ASSEMBLY	
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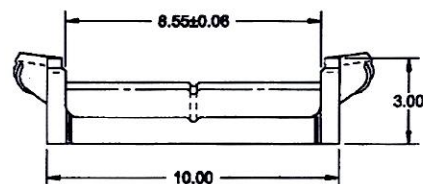
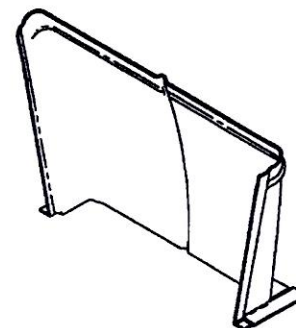
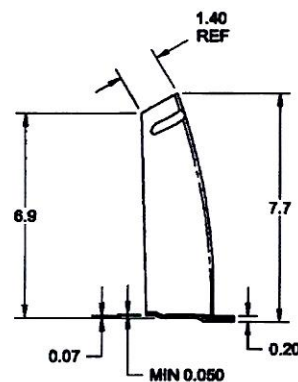
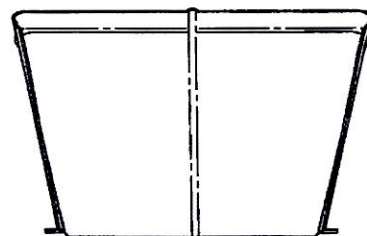
D212-725-1-251 FWD DUCT

NOTES:

- 1) MATERIAL: LEXAN F8000 POLYCARBONATE, 0.003 THICK, SUEDE/POLISHED TEXTURE, BLACK SHEET
REF DART SPEC. MLEXS.093-F8008-02
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9581 PER QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

RELEASED
2013-10-07
ND

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO. D4065	REV. C
MFG. APPR.	[Signature]	SHEET 3 OF 4	
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	DUCT ASSEMBLY	NTS
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D212-725-1-253 AFT DUCT

RELEASED
2013-10-07

NOTES:

- 1) MATERIAL: LEXAN F8000 POLYCARBONATE, 0.093 THICK, SUEDE/POLISHED TEXTURE, BLACK SHEET
REF DART SPEC. MLEXS.083-F6006-02
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.38 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9581 PER QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4065	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DUCT ASSEMBLY	NT6
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Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 23296
Shipment Date: 07/11/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE LTD.
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order TBD		Sales Order SO-019004		Incoterms		Payment Method	
Carrier Account #		Ship Via BESTWAY -		Tracking Number			
Item Number - Revision	Description					Quantity Shipped	UOM
CUSTOM -	BLACK POLYCARBONATE LEXAN F6000 TEXTURED HS Code: 8708.8.1000 - Country of Origin : CA P/N D4065 0.093" THICKNESS					1	EA

SP17-7-14

DAS
9-888
9-89

Number of Containers

Gross Weight

Shipped By



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36772**

Purchase Order Date 6/20/2017

PO Print Date 6/20/2017

Page Number 1 of 2

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 21 2017

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 60
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D412-711-101P MANUFACTURE AS PER DWG D412-711-101 REV. C B163003	Replacement Bubble Window	6/27/2017 Yes 6/27/2017		2.00 Each	\$225.75	\$451.50
Line Total:							\$451.50
2	D212-725-1-251 MANUFACTURE AS PER DWG D4065 REV. C (D212-725-1-251/253) B163005	Forward Duct	6/27/2017 Yes 6/27/2017		1.00 Each	\$148.75	\$148.75
Line Total:							\$148.75

Note:

6/20/2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36772

Purchase Order Date 6/20/2017

PO Print Date 6/20/2017

Page Number 2 of 2

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 60
Currency CAD
FOB Destination-Collect

3	D212-725-1-253	Aft Duct	6/27/2017	1.00	\$148.75	\$148.75
			Yes	Each		
			6/27/2017			
	MANUFACTURE AS PER DWG D4065 REV. C (D212-725-1-251/253)					
	B163005					

Line Total: \$148.75

4	71401-45	PROCUREMENT QUALITY CLAUSES	6/27/2017	1.00	\$0.00	\$0.00
			No			
			6/27/2017			
	Procurement Quality Clauses					
	A004 faa-pma/tso					
	A005 right of entry					
	A016 personnel qualification					
	A025 certification of conformance					
	A040 notification of quality escape					
	A041 quality management					
	A042 dart noyification by supplier					
	A043 retention of quality documents					

8017-17-14

Line Total: \$0.00

PO Total: \$749.00

DAS
38
9-89

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 6/20/2017

